

Date: Tuesday, 12/12/2006 10:29:57 AM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MIDDLE CROSS BEAM
Job Number	: 29886		
Estimate Number	: 11738		
P.O. Number	: N/A	Part Number	: D2796
This Issue	: 12/12/2006 S.O. No. : N/A	Drawing Number	: D2796 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : MACHINED PARTS	Drawing Revision	: C
Previous Run	: N/A	Material	: N/A
Written By	: <i>[Signature]</i>	Due Date	: 1/15/2007
Checked & Approved By	: <i>[Signature]</i> 06/12/27	Qty:	6 Um: Each
Comment	: Est. 00.08.14 Added dwg D2764, and note in step #1 EC		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B1000X02500	6061-T6 Bar 1.0" x 2.5"
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Comment: Qty.: 4.2875 f(s)/Unit Total : 25.7248 f(s)

6061-T6 Bar 1.0" x 2.5"

Material: 1" X 2.5" 6061-T6 (QQ-A-200/8)

Batch No: M103019/2 pcs

M103039/4 pcs

J.F. 06/12/27 (6)

2.0	BAND SAW	BAND SAW
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Comment: BAND SAW

Cut Blanks: 48.5"

\*\*\* RUN D2764 WITH SAME PROG. \*\*\*

J.F. 06/12/27 (6)

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: HAAS CNC VERTICAL MACHINING #1

Machine per Folio D2796

Deburr

J.L./J.F. 06/12/27

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L./J.F. 06/12/27

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

*[Signature]* 070201

(6)

4.1 QC8

second check

mk 06/12/28

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☒ DQA: ☒ Date: 07/01/15

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 12/12/2006 10:29:58 AM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIDDLE CROSS BEAM

Job Number: 29886

Part Number: D2796

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

ER/am

07/01/12

(6)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

ER 7/1/12

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5155

ER 07/01/12 (6)

ER 7/1/12

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(6)

Comment: FINAL INSPECTION/W/O RELEASE

07/01/15

Job Completion



U 07-01-15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

DART AEROSPACE LTD		Work Order: 29886
Description: MIDDLE CROSS BEAM		Part Number: 02796
Inspection Dwg:	Rev: <del>0</del> C	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article

☒ Prototype

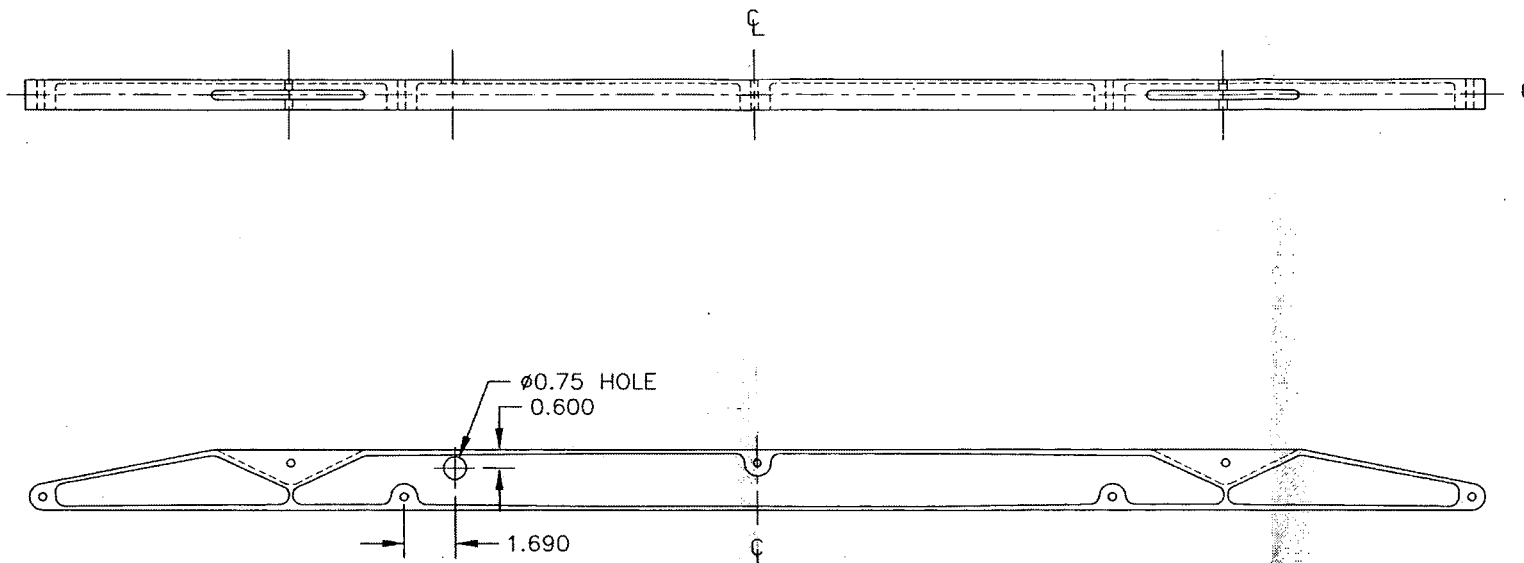
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø, 75"	±, 030"	Ø, 749"	✓			
, 600"	±, 010"	, 604"	✓			
1, 690"	±, 010"	1, 691"	✓			
, 312"	±, 010"	, 316	✓			
1, 000"	±, 010"	1, 007"	✓			
, 125"	±, 010"	, 124"	✓			
, 188"	±, 010"	, 188"	✓			
, 125"	±, 010"	, 130"	✓			
2, 000"	±, 010"	2, 007"	✓			
, 438"	±, 010"	, 438"	✓			
5, 02"	±, 030"	5, 02"	✓			
11, 950"	±, 010"	11, 942"	✓			
3, 750"	±, 010"	3, 750"	✓			
Ø, 257"	±, 006"	Ø, 258"	✓			
, 438"	±, 010"	, 439"	✓			
47, 40"	±, 030"	47, 40"	✓			
31, 000"	±, 010"	31, 000"	✓			
15, 500"	±, 010"	15, 500"	✓			
1, 150"	±, 030"	1, 140	✓			
Ø, 438"	±, 010"	, 438	✓			

Measured by: J.F./SL
Date: 06/12/27

Audited by: <i>mf</i>
Date: 06/12/28

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



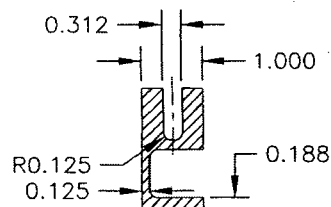
NO. 29884  
 WORK ORDER  
 WITHOUT NOTICE  
 UNCONTROLLED COPY  
 SUBJECT TO AMENDMENT  
 ENGINEERING  
 RETURN TO  
 SHOP COPY

MATERIAL: MAKE FROM D2764  
 FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
 TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

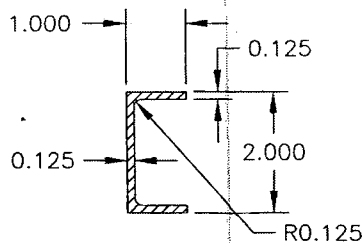
RELEASED  
 99.11.19 KE



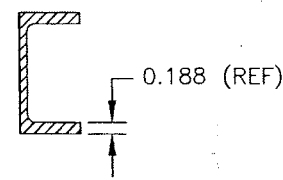
C	98.11.09	REMOVED WIRE SLOT, TAPERED WALLS
B	98.09.02	MACHINED PART WAS BOX BEAM
A	98.06.30	NEW ISSUE
DESIGN KE	DRAWN BY KE	<b>DART</b> DART AEROSPACE LTD HAMPSHIRE, ONTARIO, CANADA
CHECKED JA	APPROVED JA	DRAWING NO. D2796
DATE 98.11.09	TITLE MIDDLE CROSS BEAM	REV. C SHEET 1 OF 1 SCALE 1:4



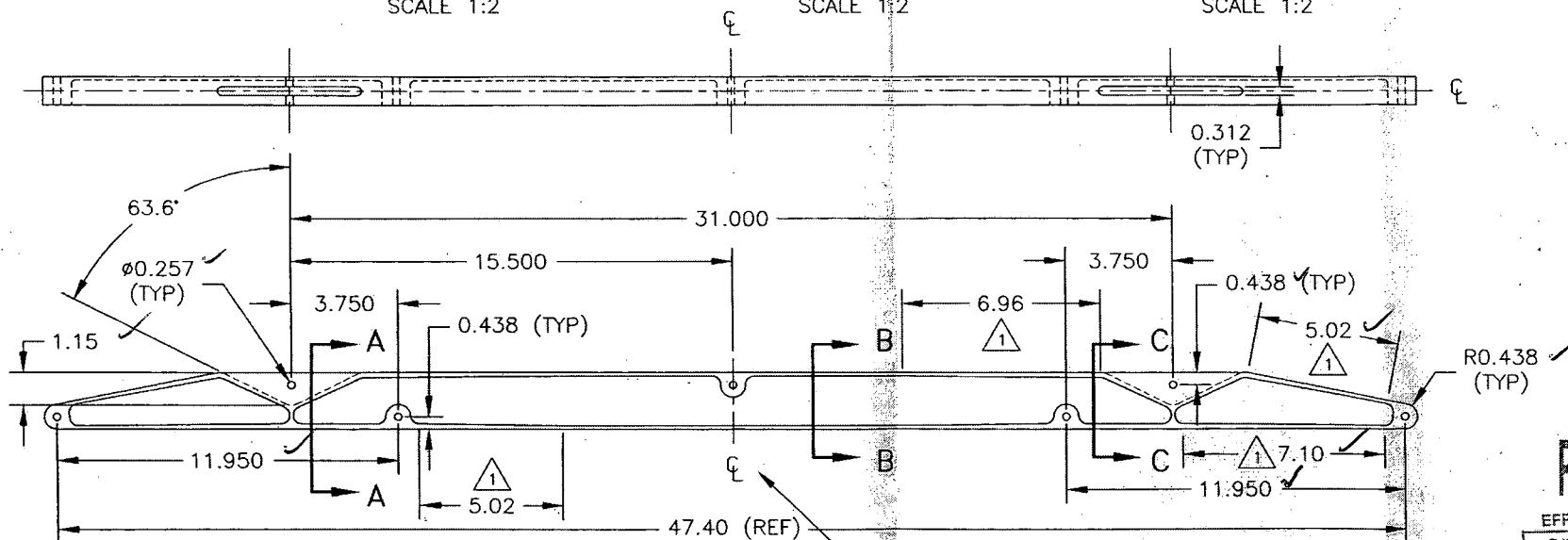
SECTION A-A  
SCALE 1:2



SECTION B-B  
SCALE 1:2



SECTION C-C  
SCALE 1:2



PART IS SYMMETRIC  
ABOUT THIS CENTER LINE

RELEASED  
98.11.13 KE

EFFECTIVE DEOS

9126

NO. 21886  
WORK ORDER  
SUBJECT TO ATTENDMENT  
WITHOUT NOTICE  
UNCONTROLLED COPY  
ENGINEERING  
RETURN TO  
SHOP COPY

MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) OR (QQ-A-225/8) KE  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED  
TSR A 1091

1 TAPERED WALL THICKNESS FROM 0.188 TO 0.125 OVER INDICATED LENGTH

D	98.11.09	TAPERED WALLS ADDED
C	98.09.01	MACHINED PART WAS BOX BEAM
B	98.06.17	ADD LARGE HOLES & STIFFENER
A	98.04.14	NEW ISSUE
DESIGN	KE	DRAWN BY
CHECKED	KE	APPROVED
DATE	98.11.09	TITLE
		CROSS BEAM
		DART AEROSPACE LTD MARKHAM, ONTARIO, CANADA
		DRAWING NO. D2764
		REV. 0
		SHEET 1 OF 1
		SCALE 1:4